

CLAIMS

1. Apparatus for use in welding a pour spout fitment (22) to a container (32), comprising an ultrasonic welding horn (18) formed with a recess (20) at one end thereof for receiving part of said fitment (22), an anvil (2) between an annular surface portion of which and said one end of the horn (18) are vibrantly pressed a wall of said container (32) and a flange (28) of said fitment (22) to weld said wall and said flange (22) to each other, and a head (14) fixed relative to and protruding from said anvil (2) for receiving said fitment (22) over a free end thereof, and a ring (16) substantially co-axial with said head (14) and protruding substantially radially outwards from said head (14) at an end thereof opposite to said free end for maintaining an annular, radially inner portion of said flange (28) spaced axially outwards from said annular surface portion, characterized in that the outer periphery of said ring (16) is of a diametrical dimension less than a diametrical dimension of said recess (20).

2. A method of welding a pour spout fitment (22) to a container (32), comprising causing the fitment (22) to be received over a free end of a head (14) fixed relative to and protruding from an anvil (2), and introducing said head (14) and thereby part of said fitment (22) into a recess (20) in an end of an ultrasonic welding horn (18), characterized by vibrantly pressing together, between said end of said horn

(18) and an annular surface portion of said anvil (2), a wall of said container (32) and an annular, radially outer portion of a flange (28) of said fitment (22) to weld said wall and said radially outer portion together, while maintaining an
5 annular, radially inner portion of said flange (22) axially outwardly spaced from said annular surface portion.

3. A method according to claim 2, wherein, with said fitment (22) fully received over said head (14), there is a spacing (30) between a free end surface of said head (14) and
10 a facing surface of said fitment (22).

4. A method according to claim 2 or 3, wherein, with said fitment (22) fully received over said head (14) and said horn (18) not yet applied to said wall of said container (32), there is a spacing of from 0.2mm. to 0.5mm. between
15 said annular surface portion of said anvil (2) and said annular, radially outer portion of said flange (28).